

CLAIMS

- 1/ A method of injection molding a receptacle (13) fitted with a covering label (1b) which is inserted into the mold (93) prior to injection, in which the label is shaped and at least two edges of the label are joined together, the method being characterized in that the shaped label is transferred and deposited on a male portion (91) of the mold by moving gripping means.
- 2/ A method according to claim 1, in which labels are used having a thickness that is less than or equal to 50 microns, and in which the shaped label is transferred by pneumatic moving gripping means.
- 3/ A method according to claim 1 or 2, in which:
- the previously-shaped, joined-together, and flattened labels (1c, 100, 103, 104) are stored flat and/or in a stack in a magazine; then
 - a label is extracted from the magazine; then;
 - the label is changed from its flattened configuration (1c) to a non-flattened configuration (1b) prior to being transferred into the mold.
- 4/ A method according to any one of claims 1 to 3, in which a plurality of labels are transferred simultaneously by said moving gripping means.
- 5/ A method according to any one of claims 1 to 4, in which, to transfer a label into the mold, a portion of the shaped and expanded label (1b) is engaged around a mold core, and then the label is put finally into place around the core by a thrust member (45).
- 6/ A method according to any one of claims 1 to 5, in which, during the operation of shaping or rolling the label, two zones or portions of the free edges (3, 5) of the label are stuck or heat-sealed together.

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7/ A method according to any one of claims 1 to 6, in which labels made of paper or of polypropylene are used.

5 8/ Apparatus for injection molding a receptacle (13) and for inserting a covering label into the mold (93), the apparatus being characterized in that it includes moving transfer means (40, 43, 44) for gripping a pre-shaped label (1b) whose two zones or edges have previously been
10 joined together and for depositing it on a male portion (91) of the mold.

9/ Apparatus according to claim 8, further comprising:
• a magazine (14, 15, 16) for storing shaped and
15 flattened labels flat or in a stack; and
• means for putting a label back into shape from a shaped and flattened state (1c) to a shaped and non-flattened state (1b).

20 10/ Apparatus according to claim 8 or 9, having means (35) for expanding a shaped and flattened label, the apparatus including moving means for pneumatically gripping a shaped label expanded by contact with an outside face of the label.

25 11/ Apparatus according to any one of claims 8 to 10, in which the moving means for transferring labels by pneumatically gripping them comprise a moving transfer support (205) fitted with a plurality (at least three)
30 means (206) for holding a shaped and expanded label (408) for transferring a plurality of labels simultaneously into a multi-cavity mold.

35 12/ Apparatus according to claim 11, in which the moving support for transferring labels comprises a plurality of identical cells or cavities (206) each suitable for

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receiving a substantial portion of an expanded label
(408).

13/ Apparatus according to claim 12, in which the moving
5 transfer support is movable by a robot (201, 203)
relative to at least two axes: one in translation and one
in rotation (shown in particular relative to three axes).

14/ Apparatus according to any one of claims 8 to 13,
10 comprising:

- means for engaging an expanded label in part on a
core; and

- thrust means (45) for pushing on a label that has
previously been engaged in part on the core (91, 93).

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